



Dart Aerospace Ltd.
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RBEA62310
Job Sheet 193342



Part No: RBEA62310

Job Qty: 6 pcs

Part Name: AS350/355 Engine Strut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/12/19

Job Tracking No:

Due Date: 5/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEA62310 Rev 1A IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	6 pcs	5/6/19	5/6/19	0.00	6.00	Small Fab - 1		DAS 71 9-89
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	6 pcs	5/6/19	5/6/19	0.00	0.00	QC 5 - 10		19-5-8
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	6 pcs	5/6/19	5/6/19	0.00	0.00	Packaging 3 - 1 - B4B		DAS 40 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S183183



Part: RBEA62310

Job No: 193342

Serial No/Batch: S183183

Revision: 1A

Inspector:

Exp Date:

Instructions:

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CANADA
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Date: 05/23/19

Plex 4/12/19 10:05 AM Dart.lajeunesse.marie

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MLL
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	

140 QC 21 - SA	6 pcs	5/6/19	0.00 0.00	QC 21 - SA - 21	MAY 23 2019
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21

Part Op 110 - 1-Cut -07 and -015 to fit as per note 1 2-Stick -07 to -01 3-Stick -015 to -09 4-Discard -17 turnbuckle hooks 5-
 Descriptions: Assemble as per DWG. Sheet 1

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
30125T403	Turn Buckle Body	6 pcs (1 ea)	110-Small Fab - 1	5145139
8997K11	Cushion w/Adhesive Back 60A durometer	3300 sf (.055 ea)	110-Small Fab - 1	5056844
RBEA62310-01	Top Weldment	6 pcs (1 ea)	110-Small Fab - 1	5149117 (4)
RBEA62310-09	Bottom Weldment	6 pcs (1 ea)	110-Small Fab - 1	5116497 (1)

Job Allocations

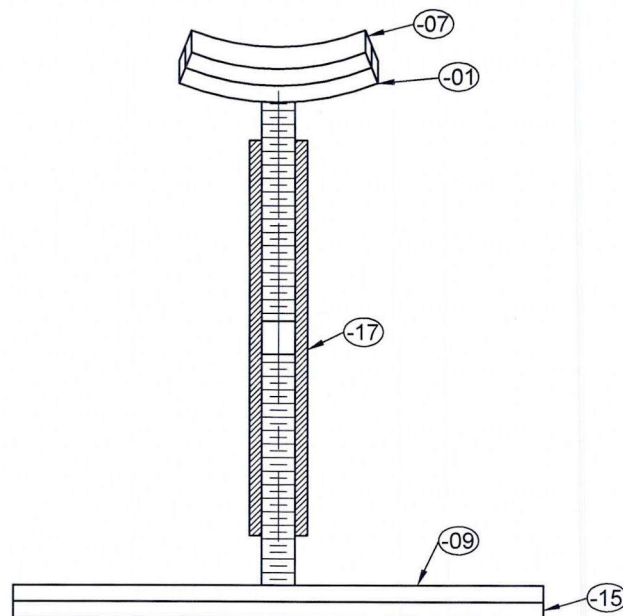
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	30125T403	6	14	0
	8997K11	0	5	0
	RBEA62310-01	6	7	0
	RBEA62310-09	6	7	0

Part Specifications

Specifications could not be found.

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	DELETED -05 10' ANGLE PER S.E. CH'D -03 BOM INFO FROM 1018 PER R.W.	5/21/12	RJC	SE
1A	CH'D TOOL NAME WAS ENGINE SUPPORT STRUT IS AS350/355 ENGINE STRUT.	11/15/16	RJC	RW



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WITHOUT NOTICE
WORK ORDER
NO. 193342 M15
1904-12

NOTES

1. CUT -07 & -15 CUSHIONS TO FIT.
2. DISCARD -17 TURNBUCKLE HOOKS.

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-01	1	TOP WELDMENT			2
	1		-03		TOP PLATE	DOM TUBE	4 X .120 WALL X 1	3
	1		-05		R/H ALL THREAD	PLAIN STEEL	1/4-20 UNC x 1-13/16 MCMaster-CARR #98750A017	4
	1		-07		CUSHION WITH ADHESIVE BACK	BLACK RUBBER	1/8 x 1 x 1-7/16 REF. (MCMaster-CARR #8997K112)	1
			-09	1	BOTTOM WELDMENT			5
	1		-11		BOTTOM PLATE	1018	1/8 x 1-3/4 x 4	6
	1		-13		L/H ALL THREAD	PLAIN STEEL	1/4-20 UNC x 1-3/4 REF. (MCMaster-CARR #95625A003)	7
	1		-15		CUSHION WITH ADHESIVE BACK	BLACK RUBBER	1/8 x 1-3/4 x 4 REF. SEE -07	1
		B/O	-17	1	TURN BUCKLE BODY	ALUMINUM	1/4-20 UNC x 3 MCMaster-CARR#30125T403	1

RED BARN MACHINE

TITLE		AS350/355 ENGINE STRUT	
DWG NO.		RBEA62310	
REV		1A	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED <i>D Weil</i>	
DECIMALS .XXX ± .005		HEAT TREAT	
XX ± .01		FINISH SEE WELDMENTS	
X ± .1		SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL	
SCALE NTS		DATE 3-10-10	
SHEET 1 of 7		EUROCOPTER AS350 & AS355	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					